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D2842-042

Job Sheet 204145



Part No: D2842-042

Job Qty: 2 pcs

Part Name: Step Assembly RH, 206 Float



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/3/19

Job Tracking No:

Due Date: 1/7/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV C IPP Rev:D As Per Ecn 766 06-01-06 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Steps - 1	2 pcs	1/7/20		0.00	2.88	Large Fab - 1		
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
105	QC 5	2 pcs	1/7/20		0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		



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Container No: S241177



Part: D2842-042

Job No: 204145

Serial No/Batch: S241177

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 01/07/20

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110 Large Fab - Steps - 2 - B4B	2 pcs	1/7/20	0.00 2.88	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	12
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
120 QC 9	2 pcs	1/7/20	0.00 0.00	QC 9 - 10	
				QC 9 - 18	DAS
				QC 9 - 24	24
				QC 9 - 43	9-89
				QC 9 - 50	
				QC 9 - 9	
130 QC 5	2 pcs	1/7/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	DAS
				QC 5 - 24	24
				QC 5 - 3	9-89
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
140 Handfinish - 1-1 Chemical-B4B	2 pcs	1/7/20	0.00 0.82	Handfinish - 1 - 1 - B4B	
				Handfinish - 1 - 2 - B4B	
				Handfinish - 1 - 3 - B4B	14 JAN 06 2020
				Handfinish - 1 - 4 - B4B	
				Handfinish - 1 - 5 - B4B	
				Handfinish - 1 - 6 - B4B	
				Handfinish - 1 - 7 - B4B	
				Handfinish - 1 - 8 - B4B	
				Handfinish - 1 - 9 - B4B	
				Handfinish - 1 - 10 - B4B	
				Handfinish - 1 - 11 - B4B	
				Handfinish - 1 - 12 - B4B	
				Handfinish - 1 - 13 - B4B	
				Handfinish - 1 - 14 - B4B	
				Handfinish - 1 - 15 - B4B	
				Handfinish - 1 - 16 - B4B	
				Handfinish - 1 - 17 - B4B	
				Handfinish - 1 - 18 - B4B	
				Handfinish - 1 - 19 - B4B	
				Handfinish - 1 - 20 - B4B	
				Handfinish - 1 - 21 - B4B	

				Handfinish - 1 - 22 - B4B	
150 QC 7	2 pcs	1/7/20	0.00 0.00	QC 7 - 10	
				QC 7 - 13	
				QC 7 - 14	
				QC 7 - 15	
				QC 7 - 17	
				QC 7 - 18	
				QC 7 - 19	
				QC 7 - 2	
				QC 7 - 28	
				QC 7 - 3	
				QC 7 - 30	
				QC 7 - 34	
				QC 7 - 36	
				QC 7 - 37	
				QC 7 - 41	
				QC 7 - 47	
				QC 7 - 48	
				QC 7 - 51	
				QC 7 - 58	
				QC 7 - 59	
				QC 7 - 60	
				QC 7 - 9	
				QC 7 - 68	DAS JAN 07 2020 68
				QC 7 - 50	9-89
				QC 7 - 67	
				QC 7 - 40	
				QC 7 - 24	
				QC 7 - 43	
				QC 7 - 61	
				QC 7 - 81	
				QC 7 - 76	
				QC 7 - 79	
160 Large Fab - Steps - 3 - B4B	2 pcs	1/7/20	0.00 2.88	Large Fab - 1 - B4B	
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
				Large Fab - 9 - B4B	
				Large Fab - 11 - B4B (Various)	
				Large Fab - 12 - B4B	
170 QC 10	2 pcs	1/7/20	0.00 0.00	QC 10 - 10	
				QC 10 - 18	
				QC 10 - 24	DAS
				QC 10 - 43	24
				QC 10 - 50	9-89
				QC 10 - 58	
				QC 10 - 9	
				QC 10 - 68	
180 QC 5	2 pcs	1/7/20	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	

					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
185 Handfinish - 2-1 Pressure-B4B	2 pcs	1/7/20	0.00 0.82	Handfinish - 2 - 1 - B4B		
				Handfinish - 2 - 2 - B4B		
				Handfinish - 2 - 3 - B4B		
				Handfinish - 2 - 4 - B4B		
190 Powdercoat - 1 White GI(A)-B4B	2 pcs	1/7/20	0.00 0.35	Powdercoat - 1 - B4B		
				Powdercoat - 2 - B4B		
				Powdercoat - 3 - B4B		
				Powdercoat - 4 - B4B		
200 QC 3	2 pcs	1/7/20	0.00 0.00	QC 3 - 10		
				QC 3 - 13		
				QC 3 - 15		
				QC 3 - 17		
				QC 3 - 18		
				QC 3 - 2		
				QC 3 - 28		
				QC 3 - 3		
				QC 3 - 30		
				QC 3 - 34		
				QC 3 - 36		
				QC 3 - 41		
				QC 3 - 51		
				QC 3 - 58		
				QC 3 - 59		
				QC 3 - 68		
				QC 3 - 9		
				QC 3 - 40		
				QC 3 - 19		
				QC 3 - 43		
				QC 3 - 24		
				QC 3 - 61		
				QC 3 - 81		
210 Handfinish - 3-1- WingWalk-B4B	2 pcs	1/7/20	0.00 0.82	Handfinish - 3 - 1 - B4B		
				Handfinish - 3 - 2 - B4B		
				Handfinish - 3 - 3 - B4B		
				Handfinish - 3 - 4 - B4B		
				Handfinish - 3 - 5 - B4B		
220 QC 5	2 pcs	1/7/20	0.00 0.00	QC 5 - 10		
				QC 5 - 12		
				QC 5 - 17		
				QC 5 - 18		
				QC 5 - 19		
				QC 5 - 22		
				QC 5 - 24		
				QC 5 - 3		
				QC 5 - 43		

				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
				QC 5 - 61	
				QC 5 - 81	
230	Packaging 3-1 - Stock - B4B	2 pcs	1/7/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
240	QC 21 - SA	2 pcs	1/7/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

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Part Op 100 - (Fabricate per Drwg) 1-Cut D2842-1 using D2622 extrusion as per Dwg D2842 2-Drill D2842-1 using Jig DT8272 as Descriptions: per Dwg D2842 ***DO NOT OPEN HOLES*** 3-Debur and bevel ends for welding

105 - QC5- Inspect part completeness to step on W/O

110 - (Weld per dwg A/R Aluminum rod Batch: 138829) 1-Weld one end cap and (2) lugs using DT10058 as per Dwg D2842 2- OPEN HOLES TO SIZE AS PER DWG (0.250") 3-Grind end cap weld flush

120 - (QC9- Inspect visual per QSI004- Fusion Welds)

130 - (QC5- Inspect part completeness to step on W/O)

140 - (Chemical Conversion Coat per QSI005 4.1)

150 - (QC7-Inspect Chemical Conversion Coat)

160 - (Weld per dwg A/R Aluminum rod Batch: B138819) 1-Remove afloat prior to welding. Weld end cap as per Dwg D2842. 2-Grind end cap weld flush.

170 - (QC10- Inspect visual per QSI004- ground welds)

180 - (QC5- Inspect part completeness to step on W/O)

185 - (Pressure Wash per QSI005 4.3/ Clean and remove all markings) ***Touch up step with alodine per qsi 005 prior to powder coat***

190 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____

200 - (QC3- Inspect Part Finish)

210 - (Wing Walk as per dwg QSI005 4.4 Batch 524646) 1-Install inserts as per Dwg D2842 2-Wing Walk as per Dwg D2842 and QSI 005 4.1 Batch: _____

220 - (QC5- Inspect part completeness to step on W/O)

230 - (Identify as per dwg & Stock Location: _____)

240 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2622-120C	Step Extrusion	2 pcs (1 ea)	100-Large Fab - Steps - 1	5221766
D2734	Step End Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	2225431
D3459-1	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	2x 5114690 2x 5011655
D3459-3	Float Step Mounting Plate	4 pcs (2 ea)	100-Large Fab - Steps - 1	5094853
MS27039C1-07	Screw	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	FM 137317-0
NAS1149C0332R	Washer (AN960C10L)	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	5233302
NAS1329C3KB130	Insert	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	PO038531
NAS1515H3L	Washer	6 Ea (3 ea)	210-Handfinish - 3-1- WingWalk-B4B	5214921

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Steps - 1	D2622-120C	2	44	0
	D2734	4	23	0
	D3459-1	4	4	0
	D3459-3	4	5	0
	MS27039C1-07	6	18	0
210-Handfinish - 3-1- WingWalk-B4B	NAS1149C0332R	6	4,438	0
	NAS1329C3KB130	6	57	0
	NAS1515H3L	6	254	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation			Disposition		Completed By Lead hand / Supervisor QC / QA Coordinator
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐			FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread		
			Other/Details:		